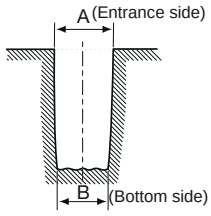
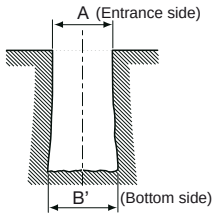
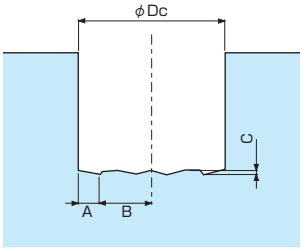
Troubleshooting (DRX type)

Trouble condition	Condition		Cause	Countermeasures
Hole diameter becomes smaller (at hole bottom)		There is no problem for entrance, however gradually hole diameter is getting smaller at the bottom. A>B	Chip jam (External or Internal edge chip stuck)	Change the cutting conditions ・Increase the cutting speed ・Lower the feed rate See page ➡ **K32** for "Recommended Cutting Conditions"
Hole diameter becomes larger (at hole bottom)		There is no problem for entrance, however gradually hole diameter is getting larger at the bottom. A<B'	Internal edge chip jam.	Change the cutting conditions ・Increase the cutting speed ・Lower the feed rate See page ➡ **K32** for "Recommended Cutting Conditions" ・Check the core height See page ➡ **K34~35**
Hole diameter is small (from the hole entrance)		Hole diameter is small from entrance. (At turning moment)	Inappropriate adjustment of hole diameter.	In case of using lathe machine, use X-axis and adjustment hole diameter. See page ➡ **K34**
			Core up for internal edge. (No core remains)	Adjust the core height. See page ➡ **K34~K35**

MagicDrill (DRX type) Hole Bottom Shape (mm)

øDc	A	B	C	øDc	A	B	C	øDc	A	B	C
13.5	2	4.8	0.5	24.5	3.2	9.1	0.8	39.0	5.8	13.7	1.5
14.0		5.0		25.0		9.3	0.9	40.0		14.2	
14.5		5.3		25.5		9.6		41.0		14.7	
15.0		5.5		26.0		9.8		42.0		15.2	
15.5		5.8	0.6	26.5	3.9	9.4	1.0	43.0		15.7	
16.0		6.0		27.0		9.6		44.0		16.2	
16.5		6.3		27.5		9.9		45.0		16.7	
17.0		6.5		28.0		10.1		46.0		17.2	
17.5		6.8		28.5		10.4		47.0		17.7	1.6
18.0		7.0	0.7	29.0		10.6		48.0	7.1	16.9	1.7
18.5	2.4	6.9	0.7	29.5		10.9		49.0		17.4	
19.0		7.1		30.0		11.1	1.1	50.0		17.9	
19.5		7.4		30.5		11.4		51.0		18.4	
20.0		7.6		31.0		11.6		52.0		18.9	
20.5		7.9		31.5		11.9	1.2	53.0		19.4	
21.0		8.1	0.8	32.0	4.7	11.3	1.1	54.0		19.9	
21.5		8.4		33.0		11.8		55.0		20.4	1.8
22.0	3.2	7.8	0.8	34.0		12.3		56.0		20.9	
22.5		8.1		35.0		12.8		57.0		21.4	1.9
23.0		8.3		36.0		13.3	1.2	58.0		21.9	2.0
23.5		8.6		37.0		13.8	1.3	59.0		22.4	
24.0		8.8		38.0		14.3		60.0		22.9	2.1



Common for 2XD, 3XD, 4XD, 5XD type

* Figures above are numeric guidelines. (Varies within ±0.1mm depending on work materials and cutting conditions)